

Work Order ID 76484

76484

Page 1

Tuesday, November 15, 2011 1:57:52 PM

Item ID: D4108-9 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fitting, Litter Door
 Start Date: 11/15/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/22/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: 11/15 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4108	A

100	Cut blanks as per folio	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	cut to 3.750"								

110		0.00							
110									
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	MILL AS PER DWG AND FOLIO FA964								
	FOLIO REV: <u>AA</u>								
	DWG REV: <u>B</u>								

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76484

76484

Page 2

Tuesday, November 15, 2011 1:57:52 PM

Item ID: D4108-9

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fitting, Litter Door

Start Date: 11/15/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/22/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

134

chemical coat →

136

QC2 →

140

Identify as per dwg & Stock Location: ST96

0.00

140

Packaging

Memo

0.00

Packaging

4 0

4 0

4 7/12/07

4 M-12/06/07

4 500 12/06/07

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 76484***76484***

Page 3

Tuesday, November 15, 2011 1:57:52 PM

Item ID: D4108-9

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fitting, Litter Door

Start Date: 11/15/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/22/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

12/6/8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Tuesday, November 15, 2011 1:58:00 PM

Page 1

Work Order ID: 76484

76484

Parent Item: D4108-9

D4108-9

Parent Item Name: Fitting, Litter Door

Start Date: 11/15/2011

Required Date: 11/22/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-10-12 VERIFIED BY:DD
Rev:B 10.12.03 as per dwg rev.B DD verf:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X03.50 0		Purchased	No			100	f	18.1311	0.3125	1.315789			

M6061T6B2 000X03 500

6061-T6 Bar 2.00 x 3.50

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT003	11.4527	
118182	11.4527	
MAT009	6.6784	
112764	0.7284	
118641	5.95	

M121660 X 1.32

amt 12/06/05

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 76484
Description: Fitting, litter door		Part Number: D4108-9
Inspection Dwg: D4108	Rev: B	Page 1 of 1

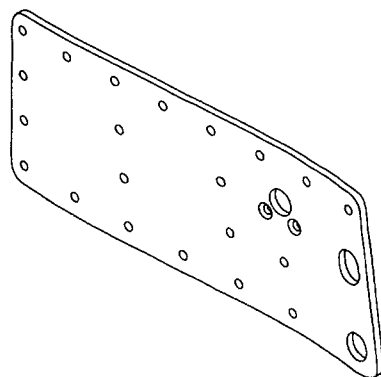
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.100	$\pm .010$.097	✓		Vern	SL-10
3.63	$\pm .030$	3.630	✓		-	
.125	$\pm .010$.121	✓		-	
.125	$\pm .010$.124	✓		-	
1.13	$\pm .030$	1.125	✓		R-G	
1.48	$\pm .030$	1.479	✓		-	
1.48	$\pm .030$	1.479	✓		-	
2.57	$\pm .030$	2.570	✓		-	
1.13	$\pm .030$.125	✓		R-G	
.66	$\pm .030$.66	✓		-	
.37	$\pm .030$.368	✓		-	
Ø.234	$\begin{matrix} +.004 \\ -.001 \end{matrix}$.238	✓		-	
.48	$\pm .03$.485	✓		H-G	
.100	±.010 $\pm .010$.097	✓		Vern	SL-10
2.06	$\pm .030$	2.054	✓		-	
.40	$\pm .030$.400	✓		-	
.27	$\pm .030$.268	✓		H-G	
Ø.316	$\begin{matrix} +.005 \\ -.001 \end{matrix}$.317	✓		Vern	SL-10
2.27	$\pm .030$	2.27	✓		H-G	
.100	$\pm .030$.097	✓		Vern	SL-10
.40	$\pm .030$.403	✓		-	
1.06	$\pm .030$	1.06	✓		H-G	
Ø.234	$\begin{matrix} +.004 \\ -.001 \end{matrix}$.238	✓		Vern	SL-10

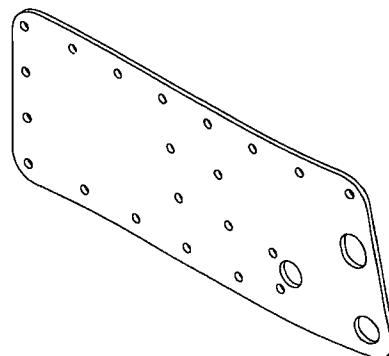
Measured by: SL	Audited by: [Signature]	Preliminary Approval:
Date: 12-06-06	Date: 12/06/06	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



D4108-1 LEFT PASS DOOR DOUBLER



D4108-3 RIGHT PASS DOOR DOUBLER

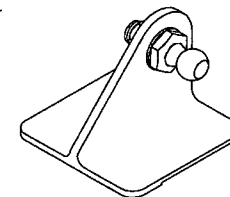


D4108-5 SMALL RIGHT DOOR DOUBLER

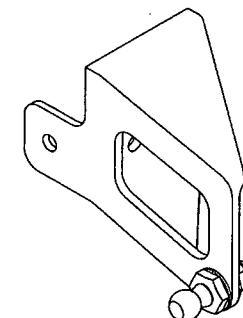


D4108-11 TEMPLATE

SHOP COPY
 RETURNED
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO CHANGE
 WITHOUT NOTICE
 WORK ORDER NO. 76484
 11-11-15



D4108-047 SILL BRACKET ASSEMBLY



D4108-049 LITTER DOOR FITTING ASSEMBLY

RELEASED
 2010-11-30

B	D4108-5 (ZN C4-1 & B4-4) VIEWS UPDATED. D4108-7-9 MTL CHANGED TO 6061-T6 AL. NOTES UPDATED (SHT 5,6)	JPH	10.11.01
A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D4108	SHEET 1 OF 7
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	DOUBLERS & FITTINGS	NTS
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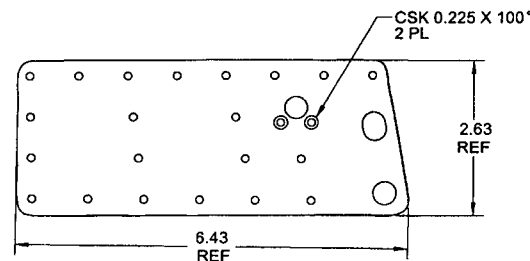
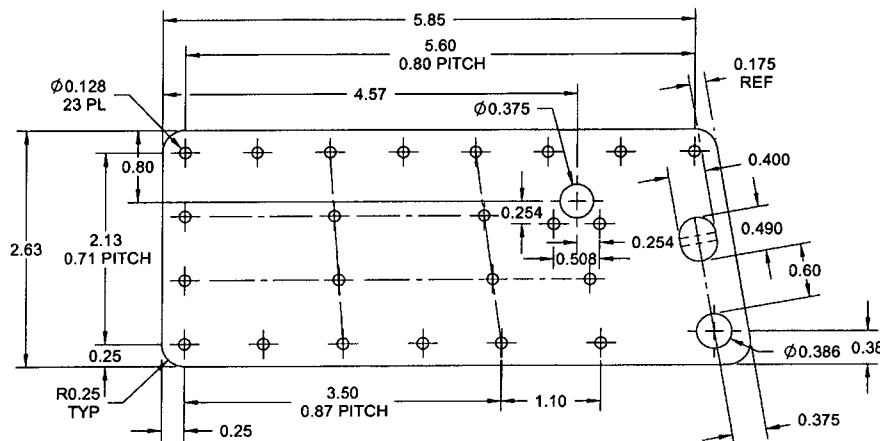
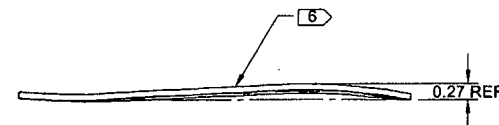
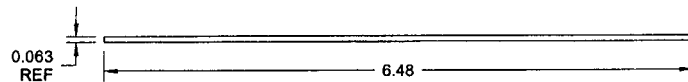
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4108-1 LEFT PASS DOOR DOUBLER (MAKE FROM D4108-1F)

D4108-1F FLAT PATTERN, LEFT PASSENGER DOOR DOUBLER

NOTES:

- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
-1: MAKE FROM D4108-1F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: -1: P/N D4108-1 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.29 lbs
- 8) FORM & INSPECTION PER TEMPLATE DT9648.

76484

RELEASED
2010-11-30
WP

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D4108	SHEET 2 OF 7
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	DOUBLERS & FITTINGS	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

0.063
REF

6.48

0.19
REFØ0.128
21 PL

5.85

5.60
0.80 PITCH2.63
2.13
0.71 PITCH

0.73

0.25

R0.25
TYP3.50
0.87 PITCH

0.25

0.508

0.254

0.254

0.400

0.490

0.60

0.38

Ø0.375

0.375

1.78

Ø0.386

6

2.59
REF6.39
REF**D4108-3 RIGHT PASS DOOR DOUBLER** B
(MAKE FROM D4108-3F)**D4108-3F FLAT PATTERN, RIGHT PASSENGER DOOR DOUBLER****NOTES:**

- 1) MATERIAL -3F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
-3: MAKE FROM D4108-3F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: -3: P/N D4108-3 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.29 lbs
- 8) FORM & INSPECTION PER TEMPLATE DT9649: ~

76484

RELEASED
2010-11-30
JW

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4108	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 7	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLERS & FITTINGS	NTS
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8

7

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5

4

3

2

1

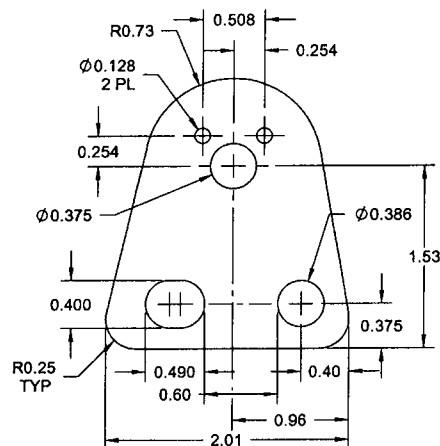
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

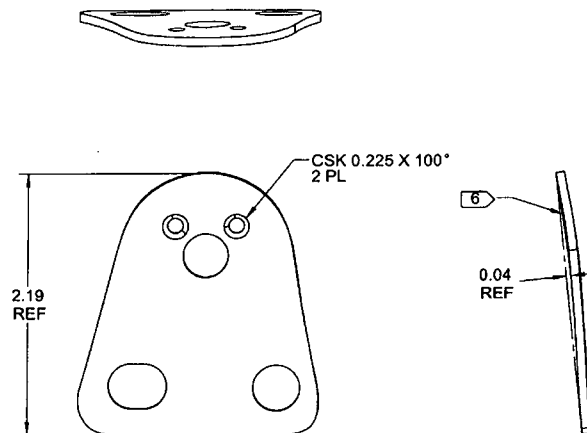
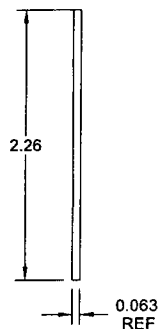
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NOTE: Date & initial all entries



D4108-5F FLAT PATTERN, SMALL RIGHT DOOR DOUBLER







D4108-5 SMALL RIGHT DOOR DOUBLER (MAKE FROM D4108-5F)

NOTES:

- 1) MATERIAL -5F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA OR M303S16GA
- 5: MAKE FROM D4108-5F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: -5: P/N D4108-5 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs
- 8) FORM & INSPECT PER TEMPLATE DT9649.

26484

RELEASED
2010-11-30
ND

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D4108	SHEET 4 OF 7
APPROVED		TITLE	SCALE
DE APPR.		DOUBLERS & FITTINGS	NTS
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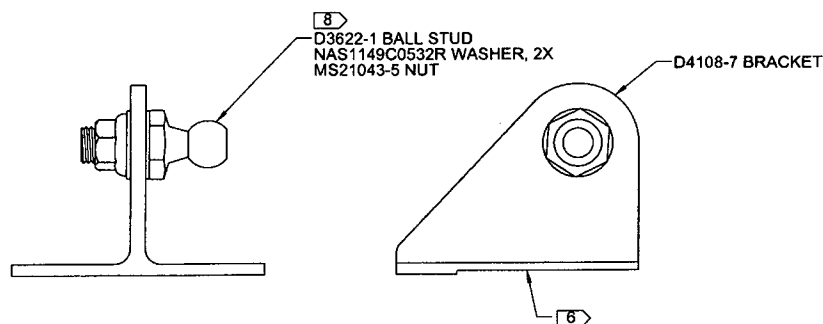
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

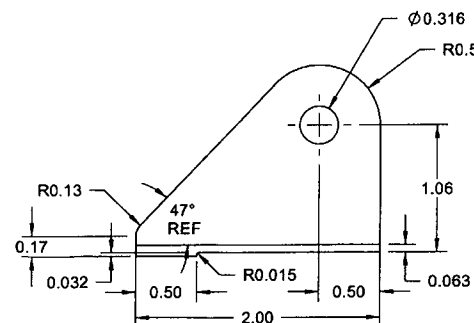
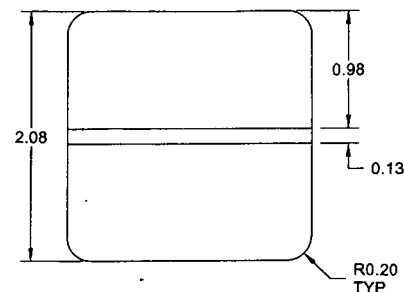
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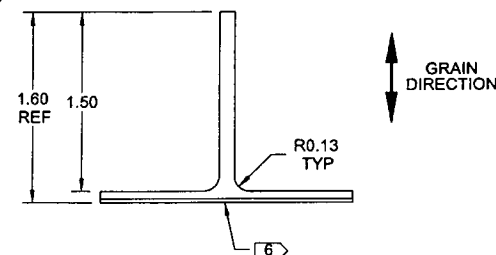
Qty	Part Number	Description
-047	D4108-047	SILL BRACKET ASSEMBLY
1	D4108-7	BRACKET
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER



D4108-047 SILL BRACKET ASSEMBLY



D4108-7 BRACKET



- NOTES:**
- 1) MATERIAL -7: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1.
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
 - 7) WEIGHT -047: 0.10 lbs
 - 8) TORQUE TO 5-10 INCH POUND.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4108	SHEET 5 OF 7
APPROVED		TITLE	SCALE
DE APPR.		DOUBLERS & FITTINGS	NTS
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RELEASED
2010-11-30

76484

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

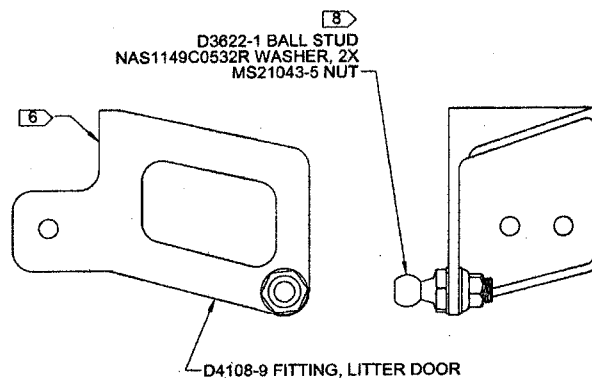
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

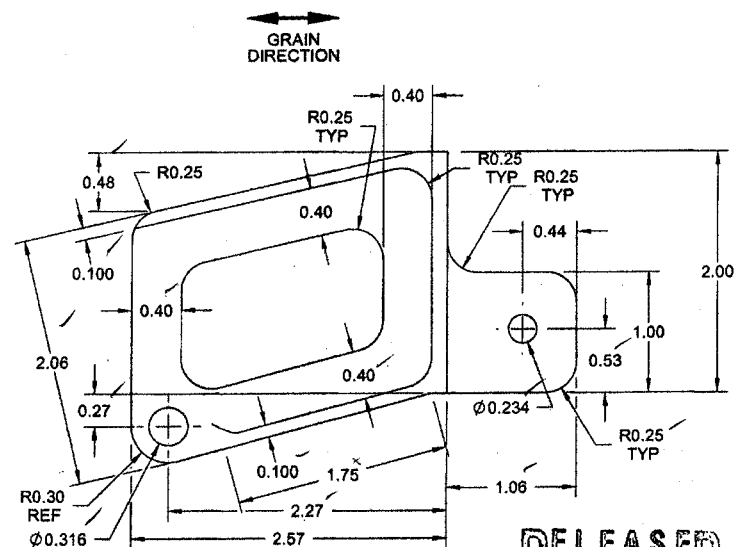
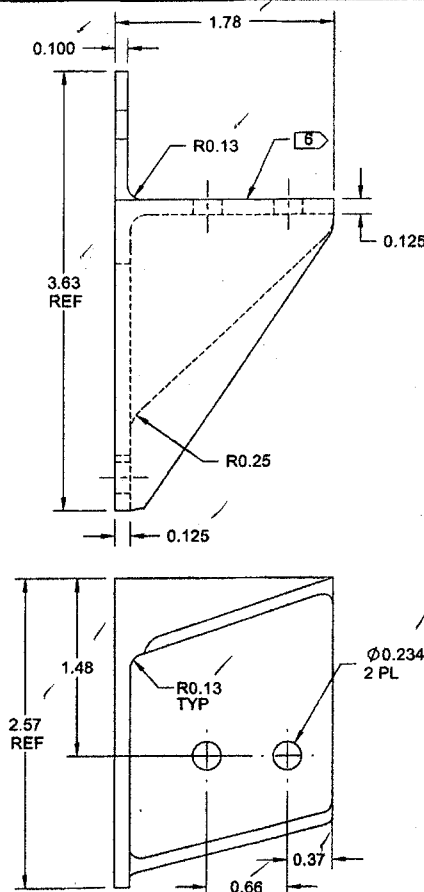
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty	Part Number	Description
-049	D4108-049	LITTER DOOR FITTING ASSEMBLY
1	D4108-9	FITTING, LITTER DOOR
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER



D4108-049 LITTER DOOR FITTING ASSEMBLY



D4108-9 FITTING, LITTER DOOR

RELEASED
2010-11-30

- NOTES:**
- 1) MATERIAL -9: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
 - 7) WEIGHT -049: 0.19 lbs
 - 8) TORQUE TO 15 INCH POUND.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.		D4108	SHEET 6 OF 7
APPROVED		TITLE	SCALE
DE APPR.		DOUBLERS & FITTINGS	NTS
DATE	10.11.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	